

Work Order ID 58959

Thursday, May 20, 2010 11:07:11 AM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 5/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-5-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: *110875*

PD 10.05.31

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PLC 10-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

8 10/03/31



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

= 2 10/05/31



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

11:30 AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

12:00 PM

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

12:00 PM

OVEN TEMPERATURE:

400°F

FINISH TIME:

12:30 PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

① BL 10-5-31

150

Identify as per dwg & Stock Location: G-A

0.00

Packaging

Memo

0.00

Packaging

W/O B58956

ES 10/06/01 ②

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/01 HJ

CZ 10/6/11

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Picklist Print

Thursday, May 20, 2010 11:07:16 AM

Page 1

Work Order ID: 58959

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly









Start Date: 5/20/2010

Required Date: 5/31/2010

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1	Manufactured	No	100	Each	23.0000	1	
							 PD 10.05.26
Rib							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		23			
		57182		1			
		57499		10			①
		58122		12			
D2989-3	Manufactured	No	100	Each	2.0000	1	
							 PD 10.05.26
Rib							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		2			
		57995		2			B59034 → ①
D2989-4	Manufactured	No	100	Each	2.0000	1	
							 PD 10.05.26
Rib							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		2			
		57996		2			B58997 → ①
D2989-5	Manufactured	No	100	Each	6.0000	2	
							 PD 10.05.26
Rib							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		6			
		57596		2			
		58061		4			②

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 5/31/2010

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IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3182-1	Manufactured	No		100	Each	8.0000	2	
Hinge								
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
			WA		8			
			57602		8			
D3442-3	Manufactured	No		100	Each	12.0000	2	
Shim								
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
			WA		12			
			53137		4			
			56204		8			
D3827-041	Manufactured	No		100	Each	10.0000	1	
Rib Assembly (Inboard)								
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
			WA		10			
			57219		4			
			57802		6			
D3832-5	Manufactured	No		100	Each	5.0000	1	
Mesh (Lid)								
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
			WA		5			
			57603		2			
			57941		3			

Thursday, May 20, 2010 11:07:16 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 5/20/2010

Required Date: 5/31/2010

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IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3833-5 Manufactured No 100 Each 15.0000 2



Mesh (Lid End)



PD 10.05.27

LocationLoc QtyLoc Code

WA

15

53722

9

57627

6

(2)

D3838-041 Manufactured No

100 Each

4.0000

1



Rib Assembly (Basket Lid, LH)



PD 10.05.26

LocationLoc QtyLoc Code

WA

4

57831

2

58059

2

(1)

D3838-042 Manufactured No

100 Each

4.0000

1



Rib Assembly (Basket Lid, RH)



PD 10.05.26

LocationLoc QtyLoc Code

WA

4

57832

2

58060

2

(1)

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 58959

10-5-20

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.050 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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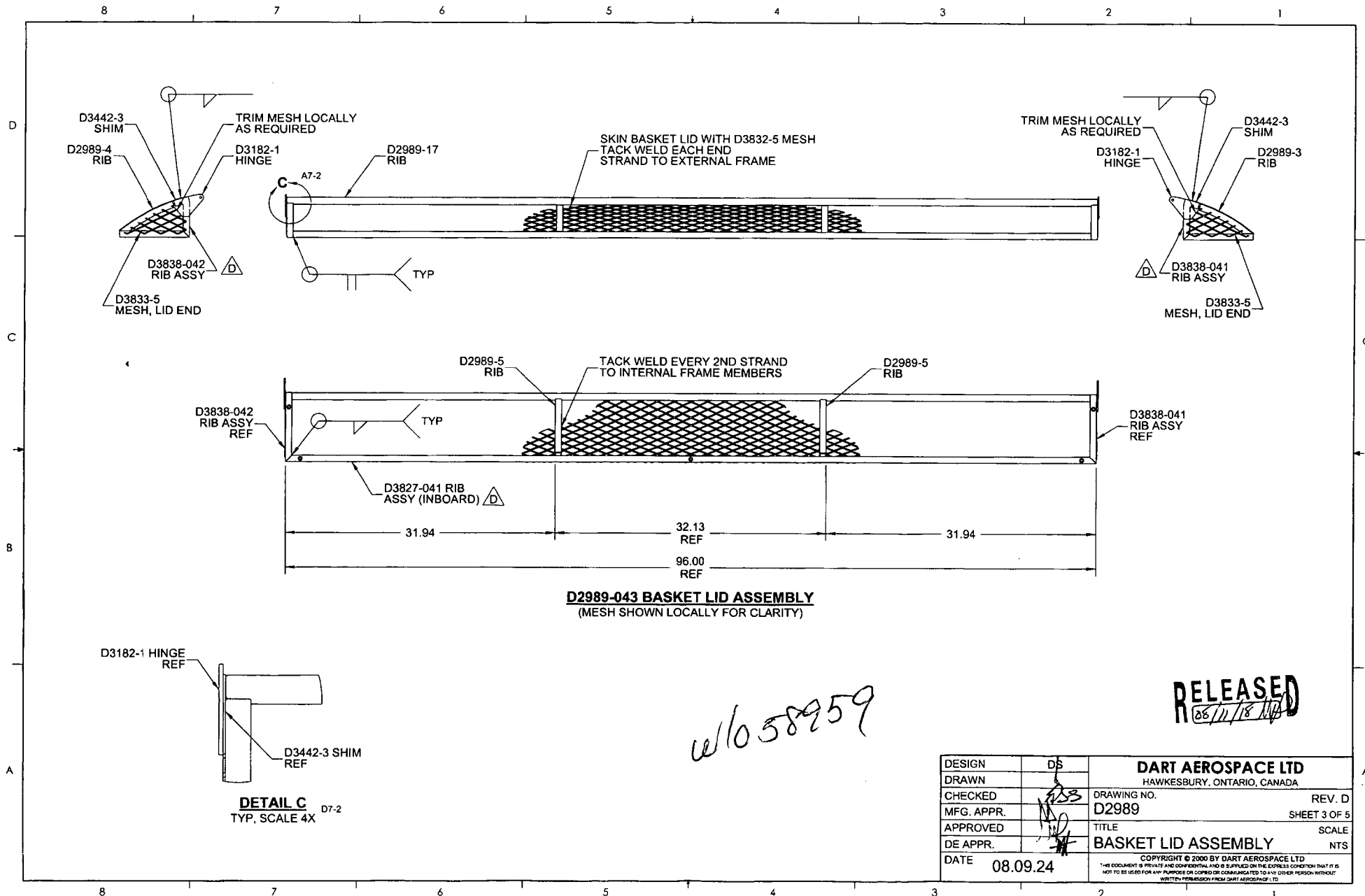
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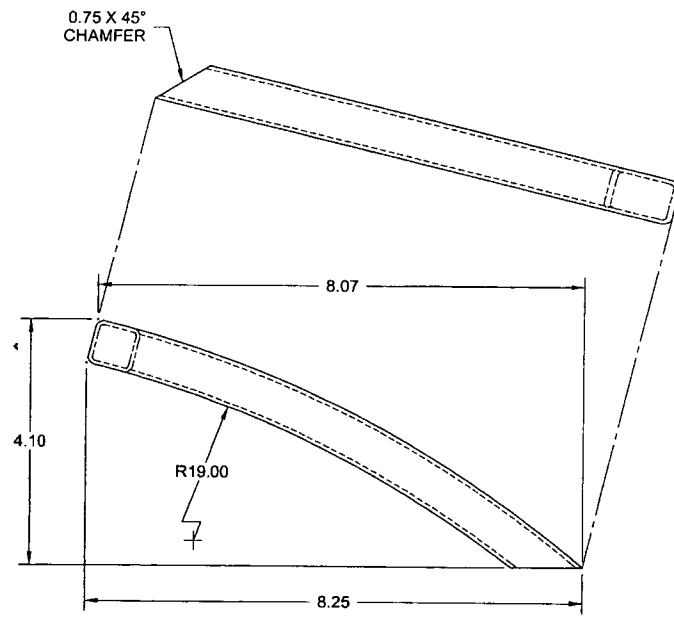
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

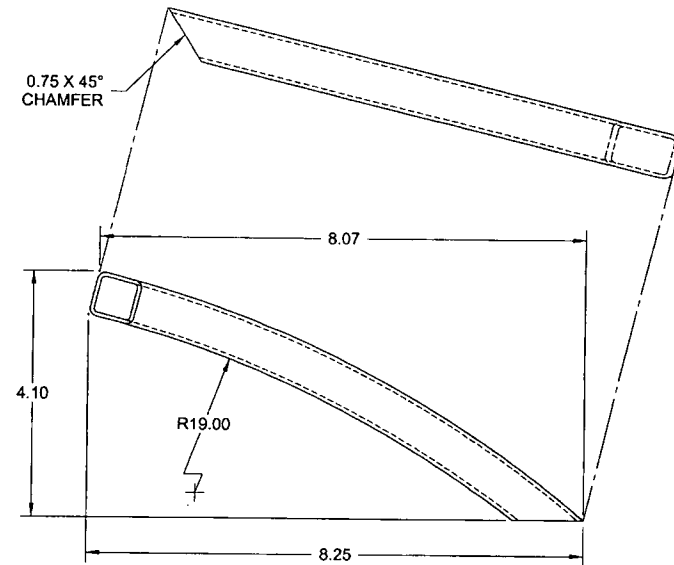
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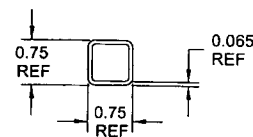
NOTE: Date & initial all entries



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

61058959

RELEASED
08/11/18 N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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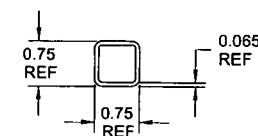
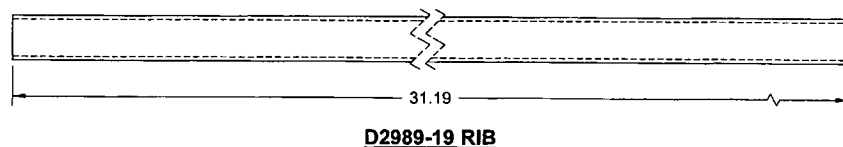
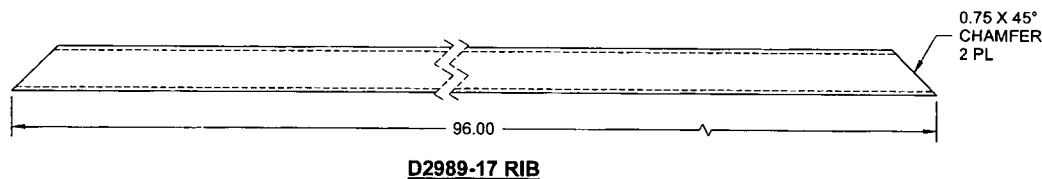
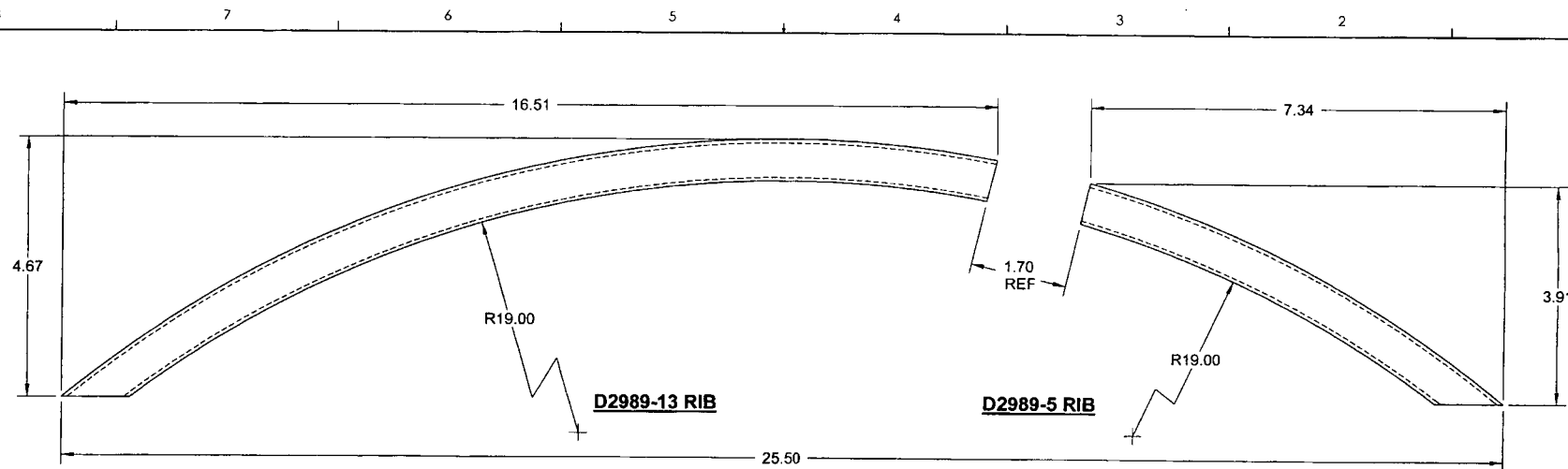
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TYPICAL SECTION VIEW

w/ 58237

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED	NT	TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NT
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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